

SPLIT - 34

Work Order ID 122691-1

122691

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Tuesday, July 22, 2014 8:43:49 AM

Item ID: D4652-1

Revision ID:

Item Name: Air Valve, 1.16 Id Disk Type

Start Date: 8/14/14 Start Qty: 36.00

Required Date: 8/19/14 Req'd Qty: 36.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 14-07-23 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4652	C

100

0.00

100

Purchasing

Purchasing

Memo

0.00

Issue P/O: 25195
Purchase Part Number: AV364302-QCP820
Supplier: BIRK AEROSYSTEM CORPORATION

Note: d4652-3 is included in the -1
Certificate of conformity is required

CL 14/07/29 120 36x

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

36x SP 15-01-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 122691

Tuesday, July 22, 2014 8:43:49 AM

122691

Page 2

Item ID: D4652-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Air Valve, 1.16 Id Disk Type
Start Date: 8/14/14 Start Qty: 36.00 ***36*** Cust Item ID:
Required Date: 8/19/14 Req'd Qty: 36.00 ***36*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				36			DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									JAN 16 2015
130	Identify as per dwg & Stock Location MF	0.00				36			DAS 38 9-89
130									
Packaging	Memo	0.00							JAN 16 2015
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									15/1/19 JA

15-1-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Supplier									
Training									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Tuesday, July 22, 2014 8:43:48 AM

1226.91

D4652-1

Required Date: 8/19/14

Required Qty: 36.00

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AV364302-QCP820		Purchased	No				Each	0.0000		36	36x		
AV364302-QCP820									**	120	80	15-01-14	
Air Valve (Satin Black)													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

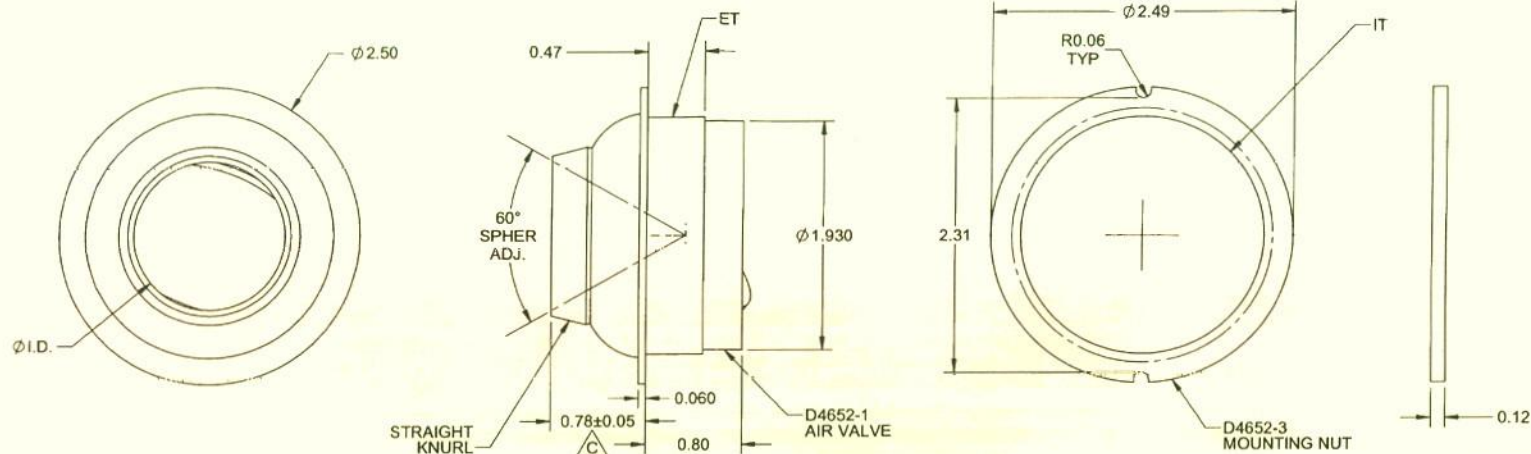
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Design									
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Equip/Tooling									
Handling/Pre									
Material									
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SPECIFICATION CONTROL DRAWING



D4652-X AIR VALVE/ MOUNTING NUT

DART PART NUMBER	DESCRIPTION	VENDOR	VENDOR PART NUMBER	MATERIAL	FINISH	INSIDE DIAMETER "ID"	MOUNTING NUT TYPE	EXTERNAL THREAD "ET"	INTERNAL THREADS "IT"	WEIGHT (lbs)
D4652-1	AIR VALVE	BIRK AEROSPACE CORPORATION	AV364302	ALUMINUM	QCP820 SATIN BLACK	1.25	ALUMINUM	2.00-24 UNS-2A	N/A	0.08
D4652-3	MOUNTING NUT	BIRK AEROSPACE CORPORATION	MN8005-1	ALUMINUM	QCP820 SATIN BLACK	N/A	ALUMINUM	N/A	2.00-24 UNS-2B	0.02

NOTES:

- 1) MATERIAL: PER TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: PER TABLE
- 8) PURCHASE VENDOR ASSEMBLY P/N AV364302-QCP820. VENDOR ASSEMBLY INCLUDES AV364302 AND MN8005-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122691 MCL5
14-07-23

C	REVISE VENDOR P/N AND SPECIFICATIONS (ZN B4-1,B5-1, B6-1 & A8-1)	RF	13.11.08		
B	ADD P/N TABLE/DESCRIPTION	RF	12.11.30		
A	NEW ISSUE	RF	12.07.25		
REV.	DESCRIPTION	BY	DATE		
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	DC			DRAWING NO.	REV. C
MFG. APPR.	MG			D4652	SHEET 1 OF 1
APPROVED	5			TITLE	SCALE
DE APPR.	5	AIR VALVE	NTS		
DATE	13.11.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25195

Purchase Order Date 7/29/2014

PO Print Date 9/25/2014

Page Number 1 of 2

Ship From:
DART AEROSYSTEMS CORPORATION
121 COMMERCIAL DRIVE
KIRKLAND GROVE, CALIFORNIA 92843

VU-BIR001

Ship To: DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name
Vendor Phone 714-554-9782
Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA - (Free Carrier)

Ref	Reference	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Ext
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Vendor Part Number

Our Comments

Delivery Comments

Promise Date

Air Valve (Satin Black)

10/17/2014 FN
Yes
10/17/2014

120.00
Each

\$262.00

QCP820 QCP820
DWG D4652 REV. C

Recu 16x

Plating to carry out finishing to match QCP820 as per supplied sample.

Recu 48x SP14-148 SP14-10

Recu 20 12/12/11 SP

Recu 36x SP 15-01-14

Line Total:

001-05

PROCUREMENT
QUALITY CLAUSES

10/17/2014

1.00

\$0.00

No

10/17/2014

PROCUREMENT QUALITY CLAUSES

0005 RIGHT OF ENTRY

0016 PERSONNEL QUALIFICATION

0025 CERTIFICATE OF CONFORMANCE

0030 NOTIFICATION OF QUALITY OF ESCAPE

0041 QUALITY MANAGEMENT SYSTEM

0047 DART NOTIFICATION BY SUPPLIER

0051 RETENTION OF QUALITY DOCUMENT

Note:

9/25/2014

BAC**BIRK AEROSYSTEMS CORPORATION**

14321 Commerce Drive

Garden Grove, California 92843

Telephone: (714) 554-9782 Telefax: (714) 554-3659

DATE: 1/13/15

CUSTOMER PO: PO25195

SHIPPER NO.: DAR150113

CERTIFICATE OF CONFORMITY / PACKING LIST

SHIP TO: **DART AEROSPACE LTD**
1270 ABERDEEN
HAWKESBURY ON K6A 1K7
Canada

PO ITEM	PRODUCT NO.	DESCRIPTION	QUANTITY		LOT CODE	LOT QTY	SERIAL NO.
			ORDERED	SHIPPED			
1	AV364302-QCP820	AIR VALVE(SATIN BLACK) (BAC P/N: AV364304-2SP00 Rev. -) PART COLOR MATCHED TO QCP820	120	36	1501246 MFG: 1503	36	-
		VALUE FOR CUSTOMS: \$9432.72 USD Country of Manufacture: United States					

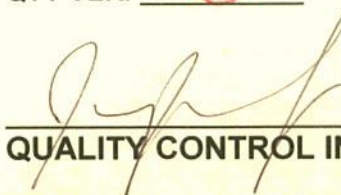
CLAIMS FOR SHORTAGES OR MATERIAL DISCREPANCY MUST BE MADE WITHIN 15 DAYS AFTER DATE SHIPPED.

CERTIFICATE OF CONFORMANCE: THIS IS TO CERTIFY THAT THE PARTS FURNISHED ON THIS ORDER HAVE BEEN FUNCTIONALLY TESTED IN ACCORDANCE WITH STANDARD PROCEDURES DEFINED BY BAC. MATERIAL AND/OR PARTS FURNISHED IN THIS ORDER HAVE BEEN MANUFACTURED IN ACCORDANCE WITH ALL APPLICABLE INSTRUCTIONS AND SPECIFICATIONS. PHYSICAL AND CHEMICAL DATA WHICH PERTAINS TO THIS ORDER ARE AVAILABLE FOR INSPECTION.

QTY VERF

**FEDEX PRIORITY COLLECT**

#9


QUALITY CONTROL INSPECTOR

